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D5203-047
Job Sheet 203190



Part No: D5203-047 **Job Qty:** 2 pcs
Part Name: Strut Weldment

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 11/11/19 **Job Tracking No:**
Due Date: 12/12/19 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**
Note: D5203 REV.C IPP REV:A 15.01.08 NEW ISSUE DD VERF:JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Basket - 1	2 pcs	12/12/19		0.00	1.92	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MV Dec 6/19
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 9	2 pcs	12/12/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		EL
							QC 9 - 9		
130	QC 5	2 pcs	12/12/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Container No: S237866



Part No: D5203-047
Job No: 203190
Material No/Batch: S237866
Revision: C
Inspector:

Dart Aerospace
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CANADA
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140	Small Fab - 2 - B4B	2 pcs	12/12/19	0.00 0.46	QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	DEC 12 2019
	QC 5	2 pcs	12/12/19	0.00 0.00	Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
	Packaging 3-1 - Stock - B4B	2 pcs	12/12/19	0.00 0.00	QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
	Packaging 3 - 1 - B4B				QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	DEC 18 2019
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
	Packaging 3 - 8 - B4B				Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
	Packaging 3 - 18 - B4B				Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	

DAS
82
9-89

DAS
81
9-89

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	DEC 24 2019 70

170 QC 21 - SA 2 pcs 12/12/19 0.00 0.00 QC 21 - SA - 53 9-89

Part Op 110 - Weld per dwg A/R S.S. rod Batch: M136685 - Weld stud to strut as per dwg GRIND WELD FLUSH

Descriptions: 120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Small Fab - Assemble nut and clevis as per dwg (HAND TIGHTEN NUT) use anti-seize on thread. A/R ANTI-SEIZE BATCH: M138973

150 - QC5- Inspect part completeness to step on W/O

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5203-3	Strut	2 pcs (1 ea)	110-Large Fab - Basket - 1	5134985
D5203-5	Stud	4 pcs (2 ea)	110-Large Fab - Basket - 1	5186410
AN665-34R	Clevis	4 Ea (2 ea)	140-Small Fab - 2 - B4B	8216251
NAS509-4C	Nut	4 Ea (2 ea)	140-Small Fab - 2 - B4B	5196065

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Basket - 1	D5203-3	2	7	0
	D5203-5	4	20	0
140-Small Fab - 2 - B4B	AN665-34R	4	33	0
	NAS509-4C	4	15	0

Part Specifications

Specifications could not be found.

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																																			
Description Work Order Deviation		Disposition																																					
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY <table><tr><td> Pressure/Forced ☐ </td><td> Contamination ☐ </td><td> Power Loss/Surge ☐ </td><td> Positioned Wrong ☐ </td></tr><tr><td> Bending ☐ </td><td> Misaligned/off center ☐ </td><td> Folio/Program ☐ </td><td> Outside Tolerance ☐ </td></tr><tr><td> Crushing ☐ </td><td> BOM/Route ☐ </td><td> Grain Direction ☐ </td><td> Drawing ☐ </td></tr><tr><td> Cracks ☐ </td><td> Broken/Damage/Defect ☐ </td><td> Weld ☐ </td><td> Finish ☐ </td></tr><tr><td> Crimp/Kink/Ripple/Wave/Twist ☐ </td><td> Incomplete/Unclear Instructions ☐ </td><td> Wrong Stock Pulled ☐ </td><td> Part Lost/Missing ☐ </td></tr><tr><td> Marks/Chatter ☐ </td><td> Drill Holes ☐ </td><td> Out of Sequence ☐ </td><td> Misread ☐ </td></tr><tr><td> Mislabeled ☐ </td><td> Fit/Function ☐ </td><td> Off-set/Set-up ☐ </td><td></td></tr><tr><td colspan="4">Other/Details:</td><td colspan="2"></td></tr></table>				Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		Other/Details:					
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Completed By		Lead hand / Supervisor																																					
		QC / QA Coordinator																																					